

Date: Friday, 2/23/2007 1:57:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE  
 Job Number : 30945  
 Estimate Number : 10833  
 P.O. Number : N/A Part Number : D29331  
 This Issue : 2/23/2007 S.O. No. : N/A Drawing Number : D2933 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : 8C  
 Previous Run : 30486 Material : N/A  
 Written By : Due Date : 3/30/2007 Qty: 8 Um: Each  
 Checked & Approved By :  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: 325345 X (8) En 07/03/21

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number. En 07/03/21  
 1-Inspect part number and batch number are programmed correctly. SA 07/03/21  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr En 07/03/21 (18)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet En 07/03/21 (19)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET En 07/03/21 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 07/03/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:57:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 30945

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

07.03.25 (8)

7.0

POWDER COATING

POWDER COATING



M103706



(8x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/03/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/3/27 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/3/27 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/28

Job Completion



07.03.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>30945</b>
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	<b>D2933-1</b>
<b>Inspection Dwg:</b> D2933 Rev. <i>BC</i>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.117	0.116	0.115	0.119		
B	0.100	0.140		0.123	0.123	0.122	0.121		
C	0.100	0.140		0.124	0.120	0.126	0.128		
D	0.210	0.230		0.221	0.221	0.221	0.220		
E	1.245	1.255		1.247	1.248	1.246	1.248		
F	1.245	1.255		1.247	1.248	1.246	1.248		
G	2.495	2.505		2.499	2.499	2.500	2.497		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.574	1.577	1.574	1.574		
J	2.495	2.505		2.499	2.500	2.500	2.497		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.239	0.238			
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.542	0.544	0.543	0.541		
P	0.490	0.510		0.495	0.500	0.497	0.499		
Q	3.715	3.725		3.718	3.718	3.720	3.719		
R	2.470	2.510		2.498	2.495	2.497	2.496		
S	0.240	0.270		0.249	0.250	0.250	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.627	1.627	1.627	1.627		
V	1.362	1.372		1.368	1.368	1.364	1.364		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.134	1.134	1.133		
Y	1.565	1.585	DT8695 A/B						
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>SR</i>
Date:	07/03/21

Audited by:	<i>SD</i>
Date:	07.03.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>30945</b>
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	<b>D2933-1</b>
<b>Inspection Dwg:</b> D2933 Rev. <i>BC</i>		<b>Page 1 of 1</b>

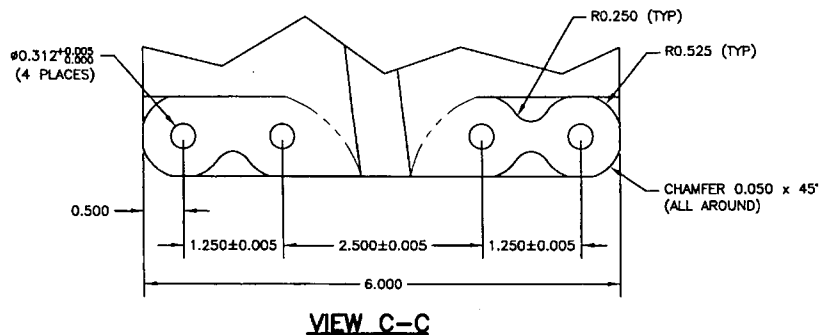
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.116	0.117	0.115	0.116		
B	0.100	0.140		0.123	0.122	0.123	0.121		
C	0.100	0.140		0.126	0.127	0.128	0.126		
D	0.210	0.230		0.223	0.221	0.222	0.220		
E	1.245	1.255		1.247	1.247	1.248	1.247		
F	1.245	1.255		1.247	1.247	1.248	1.247		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.575	1.576		
J	2.495	2.505		2.498	2.497	2.498	2.497		
K	0.257	0.262		0.259	0.259	0.259	0.257		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.547	0.547	0.543	0.543		
P	0.490	0.510		0.499	0.499	0.499	0.498		
Q	3.715	3.725		3.720	3.718	3.717	3.720		
R	2.470	2.510		2.498	2.495	2.494	2.496		
S	0.240	0.270		0.250	0.250	0.249	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.628	1.630	1.628		
V	1.362	1.372		1.367	1.364	1.365	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.134	1.136	1.132		
Y	1.565	1.585	DT8695 A/B						
Z	1.178	1.188							
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>EN</i>
Date: <i>07/03/21</i>

Audited by: <i>SA</i>
Date: <i>07.05.26</i>

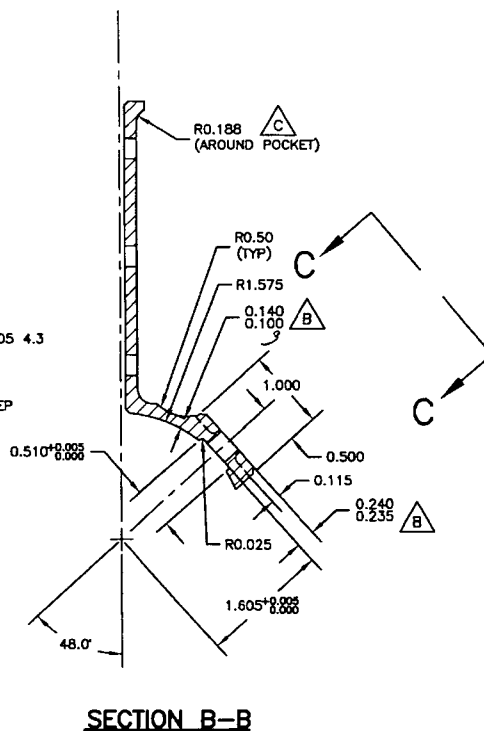
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM <i>JA</i>	<i>JA</i>



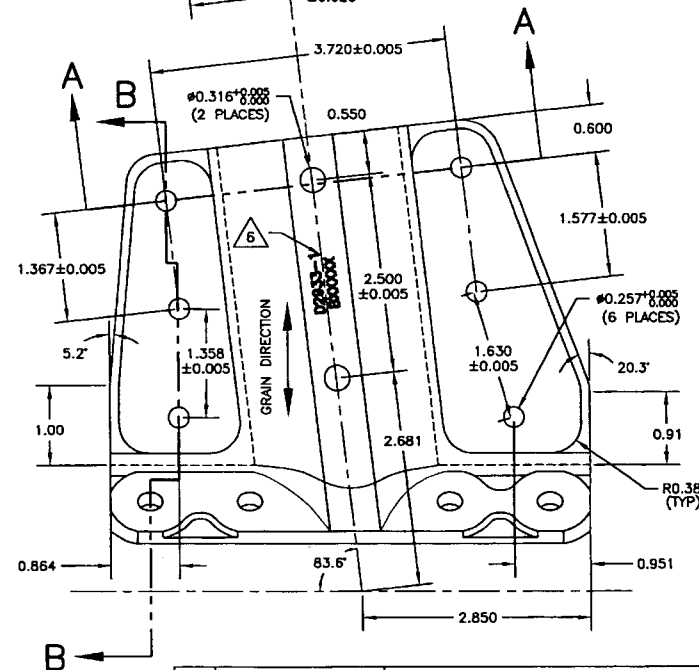
**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 30945  
 07.02.12



CHAMFER 0.050 x 45° AROUND  
 THIS SURFACE (TYP 2 PLACES)



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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